

Date: Wednesday, 03/09/2008 10:26:09 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW
Job Number : 41724	
Estimate Number : 12927	
P.O. Number :	Part Number : D29391UP
This Issue : 03/09/2008 S.O. No. :	Drawing Number : D2939 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34733	Material :
Written By :	Due Date : 26/09/2008 Qty: 3 Um: Each
Checked & Approved By : <u>JUL 08.9.03</u>	
Comment : Est Rev:A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: 34872

SB 08/09/12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
5-Deburr

SB 08/09/12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

SB 08/09/12

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SB 08/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:26:09 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER
REVIEW

Job Number: 41724

Part Number: D29391UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/09/12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JS 08-09-15 (43)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M.A 08/09/10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST444

JS 08/09/17 (43)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



MF 08-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41724
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

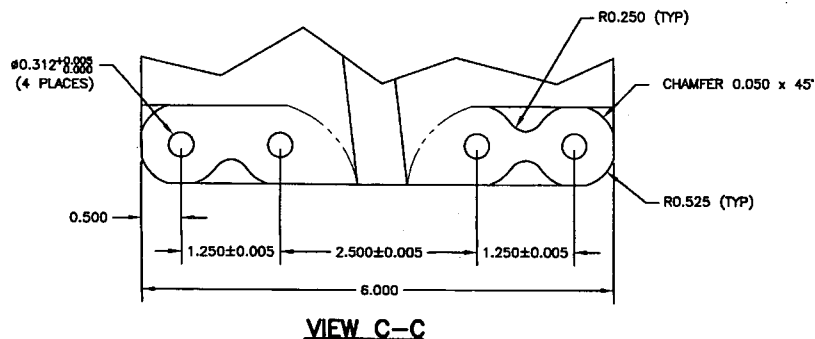
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.130	.130	.130			
B	0.100	0.140		.130	.130	.130			
C	0.100	0.140		.114	.114	.114			
D	0.210	0.230		.225	.225	.225			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	.510	.510			
I	1.572	1.582		1.578	1.578	1.578			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.314	.314	.314			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.112	.111	.111			
O	0.540	0.560		.550	.550	.550			
P	0.490	0.510		.510	.505	.505			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.720	2.760		2.740	2.740	2.740			
S	0.240	0.270		.260	.260	.260			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.628	1.628	1.628			
V	1.362	1.372		1.370	1.370	1.370			
W	0.316	0.321		.320	.320	.320			
X	1.250	1.270		1.260	1.260	1.260			
Y	1.565	1.585	DT8695 A/B	1.570	1.580	1.570			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SB/O</i>
Date: <i>08/04/12</i>

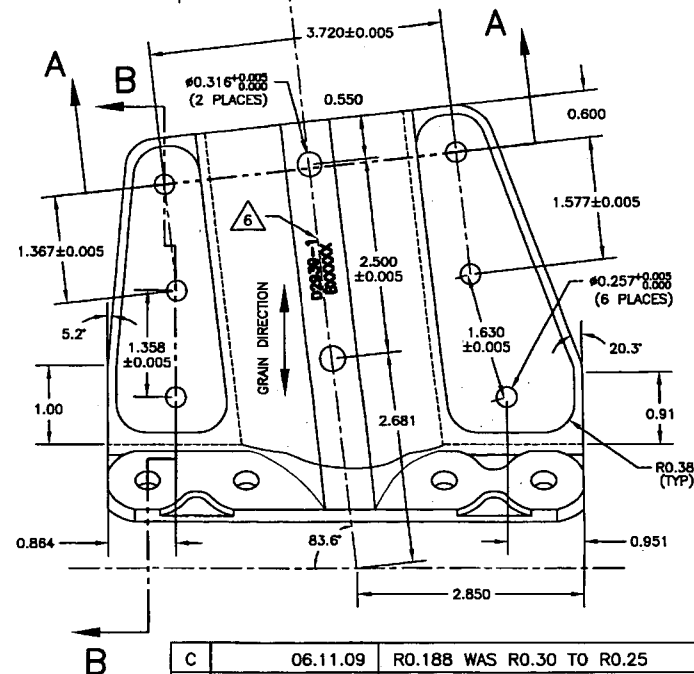
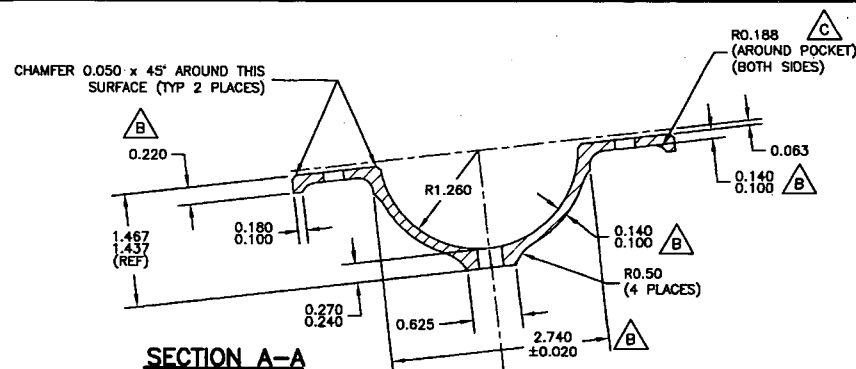
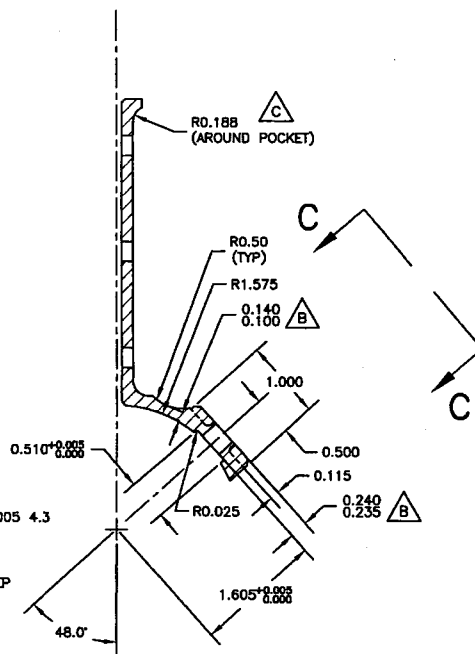
Audited by: <i>SL</i>
Date: <i>08/09/12</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	SADDLE INSIDE
06.11.09		

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 DART AEROSPACE USA, INC.

REV. C
 SHEET 1 OF 1
 SCALE
 2:3

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 NO. 112217

07.02.12